

81668

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 16/03/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 30/03/2012 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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K10004 Rev E

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile for K10004, D205-594-011/-013/-015 & D412-652-011/-21
and type labels per PPP K10004 CHG005

105

Pick Kit

0.00

105

Memo

0.00

Packaging

Packaging

110

QC4- 100% Inspect kits for completeness

0.00

110

Memo

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81668

81668

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Item ID: K10004 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, D205-594-011/-013
 Start Date: 16/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 30/03/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: 129	0.00				42		6/8/12	
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MUT 12/08/17

YMF 12-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81668

81668

Parent Item: K10004

K10004

Parent Item Name: Saddle, D205-594-011/-013

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP : D05.07.22Reformat; Added D3428-3 per CHG003KJ/JLM
IPP Rev:E 08-09-29 revD as per dwg DD verified by: IPP Rev:F
chg005 DD 10.06.03 verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-51A Bolt		Purchased	No			105	Each	206.0000	06	64			
-----------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

AN4-51A

Location	Loc Qty	Loc Code
ST361	206	
119798	30	
120187	126	
120986	50	

AN5-15A Bolt		Purchased	No			105	Each	99.0000	32	128			
-----------------	--	-----------	----	--	--	-----	------	---------	----	-----	--	--	--

AN5-15A

Location	Loc Qty	Loc Code
ST338	99	
115159	49	
115316	50	

AN5-36A Bolt		Purchased	No			105	Each	162.0000	2	8			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

AN5-36A

Location	Loc Qty	Loc Code
ST340	162	
120187	112	
120731	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81668

Parent Item: K10004

Parent Item Name: Saddle, D205-594-011/-013

81668

K10004

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

AN5-42A Purchased No

AN5-42A

Bolt

105 Each 30.0000

2 8

**

Location

Loc Qty

Loc Code

ST340

30

108442

10

119438

10

119449

10

6x 108442

2x 119449

2 8

**

AN5-43A Purchased No

AN5-43A

Bolt

105 Each 42.0000

2 8

**

Location

Loc Qty

Loc Code

ST340

42

112243

42

105 Each 14.0000

2 8

**

Location

Loc Qty

Loc Code

ST340

14

112489

14

105 Each 0.0000

2 8

**

AN960JD516 NAS1149D0563J Purchased No

AN960JD516

Washer

D205-641-011

Manufactured No

D205-641-011

Ground Handling Wheel

105 Each 1.0000

2 8

**

Location

Loc Qty

Loc Code

FG125

1

70533

1

112489

80 320

127x119246

193x121255

2 8

4x81687

2x83990

B82387 SP

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81668

81668

Parent Item: K10004

K10004

Parent Item Name: Saddle, D205-594-011/-013

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D2570 Manufactured No

105 Each 327.0000

32 128 ✓

D2570

Bushing

**

107X85413 JB
10X85411

B88329

Location

Loc Qty

Loc Code

ST011

327

72960

41

78586

19

78587

67

79493

200

D3407-041 Manufactured No

105 Each 12.0000

2 8 ✓

D3407-041

D3407-041

Tow Ring

**

7X84945 JB
1X86670

Location

Loc Qty

Loc Code

ST463

12

78877

12

D3417-5 Manufactured No

105 Each 54.0000

4 16 ✓

D3417-5

D3417-5

Washer

**

7X84943 JB
7X85466

Location

Loc Qty

Loc Code

ST042

54

77684

13

78842

41

D3428-3 Manufactured No

105 Each 9.0000

4 ✓

D3428-3

D3428-3

Placard

**

JB 12/08/07

Location

Loc Qty

Loc Code

ST042

9

51651

9

51651

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 81668

81668

Parent Item: K10004

K10004

Parent Item Name: Saddle, D205-594-011/-013

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D3456-1 Manufactured No

105 Each

83.0000

2

8

**

83584 JB

D3456-1
Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

12

77486

12

ST044

64

66848

3

71165

2

73493

9

80252

50

D5951 Manufactured No

105 Each

0.0000

2

8

**

81678 JB

D5951
D5951
Saddle, 205

D5953 Manufactured No

105 Each

1.0000

2

8

**

81680 JB

D5953
D5953
Saddle, 205

Location

Loc Qty

Loc Code

ST430

1

60934

1

D5955 Manufactured No

105 Each

1.0000

2

8

**

1x 60934
7x81683 JB 12/08/07

D5955
D5955
Saddle, 205

Location

Loc Qty

Loc Code

ST430

1

59447

1

1x 59447

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81668

81668

Parent Item: K10004

K10004

Parent Item Name: Saddle, D205-594-011/-013

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D5957 Manufactured No

105 Each 2.0000

2 8

D5957

Saddle, 205

**

6781684 JB

[Handwritten signature]

Location

Loc Qty

Loc Code

ST430

2

60935

2

105 Each

5,519.000

2x 60935

16

64

**

121444 JB

[Handwritten signature]

MS21042L4

Purchased No

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

5519

117441

51

117601

157

118451

133

119017

200

119075

2978

121011

2000

105 Each

1,598.000

40

160

**

JB 12/08/07

[Handwritten signature]

MS21042L5

Purchased No

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1598

116105

5

116548

43

117611

42

118179

8

119109

1500

119109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81668

81668

Parent Item: K10004

K10004

Parent Item Name: Saddle, D205-594-011/-013

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

105

Each

1,148.000

8 ✓

MS21043-4

**

122452 JB

12/08/07

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1108

119546

370

120308

738

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 LANDING GEAR PARTS LIST

QTY 594 -011	QTY 594 -013	QTY 594 -021	QTY 594 -023	QTY 596 -101	QTY 596 -103	QTY 596 -105	QTY 596 -107	Part No.	Description
X								D205-594-011	EXTENDED HEIGHT LANDING GEAR KIT (39"-205/210/212/214, UH-1H)
	X							D205-594-013	EXTENDED HEIGHT LANDING GEAR KIT (31"-205/210/212/214, UH-1H)
		X						D205-594-021	EXTENDED HEIGHT LANDING GEAR KIT (39"-204, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K)
			X					D205-594-023	EXTENDED HEIGHT LANDING GEAR KIT (31"-204, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K)
1		1		X				D205-596-101	CROSSTUBE ASSEMBLY, HI HI FWD
1		1			X			D205-596-103	CROSSTUBE ASSEMBLY, HI HI AFT
	1		1			X		D205-596-105	CROSSTUBE ASSEMBLY, HI HI FWD
	1		1				X	D205-596-107	CROSSTUBE ASSEMBLY, HI HI AFT
2	2							D205-634-041	SKIDTUBE ASSEMBLY (see STC SH96-88)
		2	2					D204-635-041	SKIDTUBE ASSEMBLY (see STC SH96-88)
2	2	2	2					D205-641-011	GHW KIT (see STC SH96-88)
				1				D205-596-001	FORWARD CROSSTUBE
						1		D205-596-005	FORWARD CROSSTUBE
				2		2		D2893-1	SUPPORT
				4		4		D3595-063-450	RUBBER CUSHION
				4		4		MS21920-25	CLAMP
					1			D205-596-003	AFT CROSSTUBE
						1		D205-596-007	AFT CROSSTUBE
					2	2		D2940-1	SUPPORT
					4	4		D3595-063-530	RUBBER CUSHION
					4	4		MS21920-28	CLAMP
2	2	2	2					D5951	SADDLE
2	2	2	2					D5953	SADDLE
2	2	2	2					D5955	SADDLE
2	2	2	2					D5957	SADDLE
32	32	32	32					D2570	BUSHING
16	16	16	16					AN4-51A	BOLT
32	32	32	32					AN5-15A	BOLT
2	2	2	2					AN5-36A	BOLT
2	2	2	2					AN5-42A	BOLT
2	2	2	2					AN5-43A	BOLT
2	2	2	2					AN5-45A	BOLT
16	16	16	16					MS21042L4	NUT (OR MS21042-4)
40	40	40	40					MS21042L5	NUT (OR MS21042-5)
80	80	80	80					AN960JD516	WASHER
2	2	2	2					D3407-041	TOW RING (REPLACES D2968-041) (see STC SH96-88)
4	4	4	4					D3417-5	WASHER (see STC SH96-88)
2	2	2	2					D3456-1	WASHER (REPLACES AN970-4) (see STC SH96-88)
2	2	2	2					MS21043-4	NUT (REPLACES MS21042L4)
1	1							D3428-3	PLACARD

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